

Date: Tuesday, 12/18/2007 10:51:24 AM  
 User: Kim Johnston

## Process Sheet

|  |                              |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services   | Drawing Name : WEARSHOE      |
| Job Number : 36424   |                              |
| Estimate Number : 12734  |                              |
| P.O. Number : <i>N/A</i>   | Part Number : D353525        |
| This Issue : 12/18/2007 S.O. No. : <i>N/A</i>  | Drawing Number : D3535 REV B |
| Prsht Rev. : NC  | Project Number : N/A         |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB   | Drawing Revision : B         |
| Previous Run : 35564   | Material : <i>N/A</i>        |
| Written By : <i>[Signature]</i>  | Due Date : 1/15/2008         |
| Checked & Approved By : <i>[Signature]</i>   | Qty: 20 Um: Each             |
| Comment : Est Rev:A New Issue 07-02-15 JLM<br>Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: *106292* *B 07-12-20*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3535  
 Dwg Rev: *B*  
 Prog Rev: *B*

*B 07-12-20*

2-Debur if necessary

*B 07-12-20**(20)*

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*5 07/12/08 (20)*

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326  
 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

*SAB 02/01/08 (20)*  
*[Signature] 01/02/08 SAB*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 08/07/17

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:51:24 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 36424

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/09 (20X)

7.0

POWDER COATING

POWDER COATING



M105642



(20X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-k 08/01/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



YJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-09

(20X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

YJ

08-01-09

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/09

Job Completion



08/06/11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                              |  |              |          |
|------------------------------|--|--------------|----------|
| DART AEROSPACE LTD           |  | Work Order:  | 36424    |
| Description: Wearshoe        |  | Part Number: | D3535-25 |
| Inspection Dwg: D3535 Rev: B |  | Page 1 of 1  |          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.885             | +/-0.010      | 1.888            | X      |        |                      |          |
| 1.937             | +/-0.010      | 1.937            | X      |        |                      |          |
| 1.450             | +/-0.010      | 1.450            | X      |        |                      |          |
| 5.450             | +/-0.010      | 5.455            | X      |        |                      |          |
| 10.900            | +/-0.010      | 10.900           | X      |        |                      |          |
| 16.350            | +/-0.010      | 16.350           | X      |        |                      |          |
| 21.800            | +/-0.010      | 21.800           | X      |        |                      |          |
| Ø0.188            | +0.005/-0.001 | .189             | X      |        |                      |          |
| 12.750            | +/-0.010      | 12.750           | X      |        |                      |          |
| 6.75              | +/-0.030      | 6.75             | X      |        |                      |          |
| 6.00              | +/-0.030      | 6.00             | X      |        |                      |          |
| 0.300             | +/-0.010      | .305             | X      |        |                      |          |
| 0.300             | +/-0.010      | .305             | X      |        |                      |          |
| 0.038             | +/-0.010      | .036             | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                 |                         |                     |     |
|-----------------|-------------------------|---------------------|-----|
| Measured by: JB | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 07-12-20  | Date: 07/12/21          | Date:               | N/A |

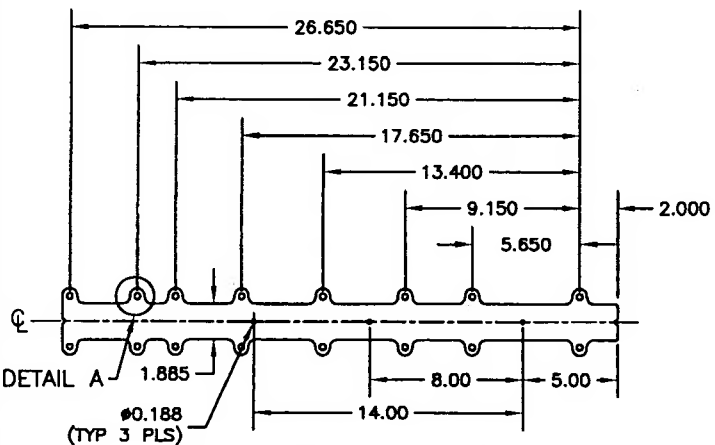
| Rev | Date     | Change    | Revised by | Approved    |
|-----|----------|-----------|------------|-------------|
| A   | 07.11.23 | New Issue | KJ/EC/DD   | [Signature] |

**DART**

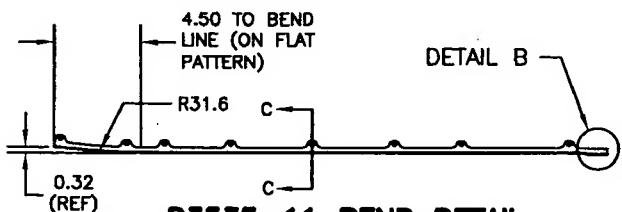
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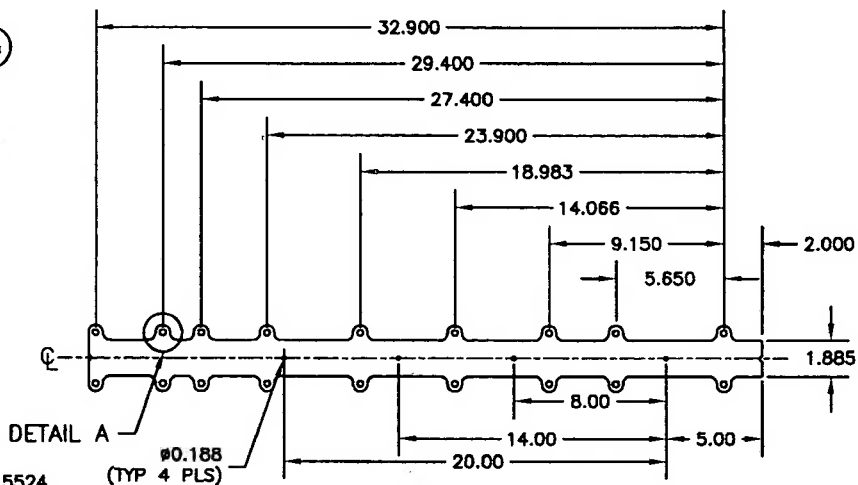
| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC.        | REV. B       |
|----------|----------|---------------------------------|--------------|
| CB       | PH       | PORT HADLOCK, WA                |              |
| CHECKED  | APPROVED | DRAWING NO.                     | SHEET 1 OF 7 |
| DATE     | DATE     | TITLE                           | SCALE        |
| 07.04.17 | 06.10.25 | WEARSHOE                        | 1:10         |
| A        | 07.04.17 | NEW ISSUE                       |              |
| B        |          | MOVE TAB OUTBOARD, ADD AMS SPEC |              |



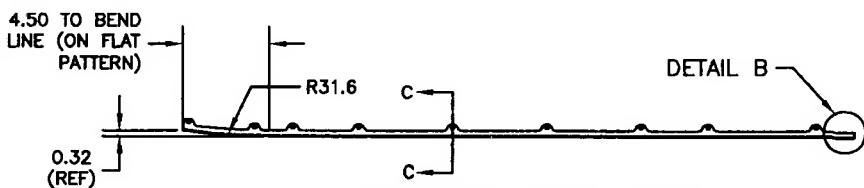
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

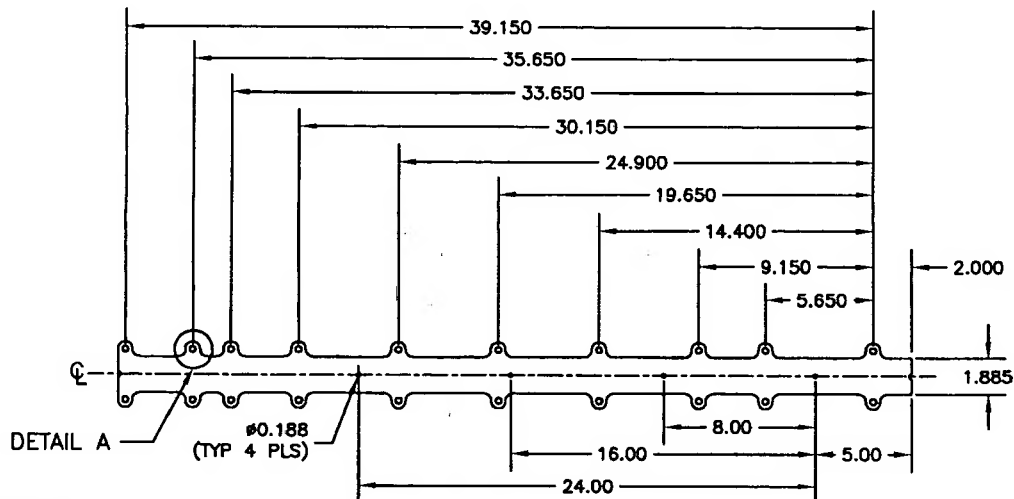
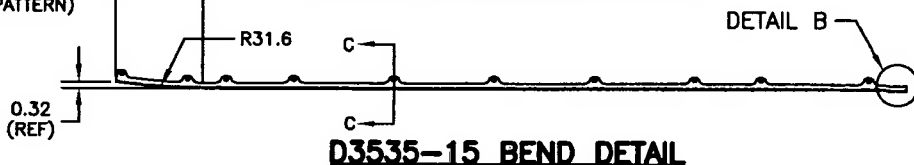
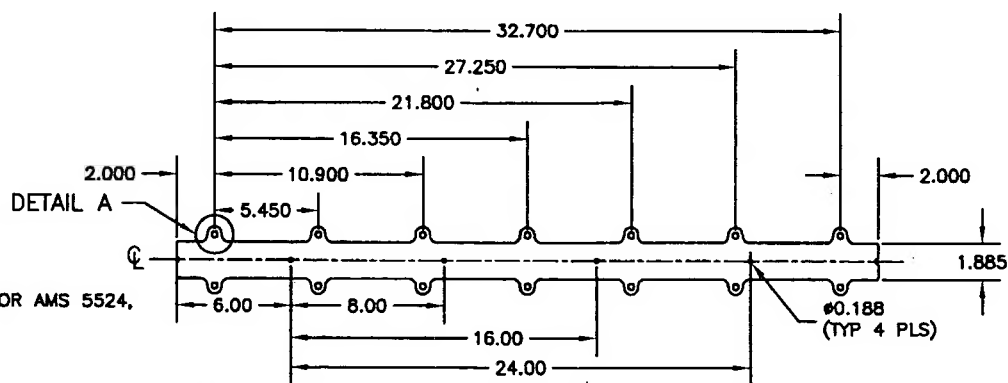
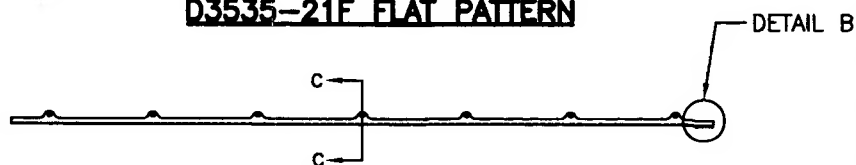
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| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 2 OF 7             |
|         |                    |             |                    | SCALE 1:10               |

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

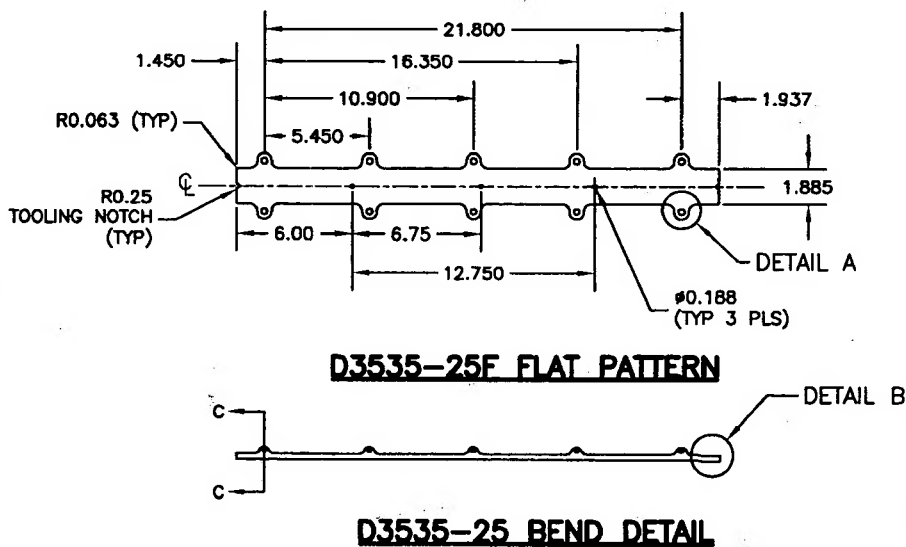
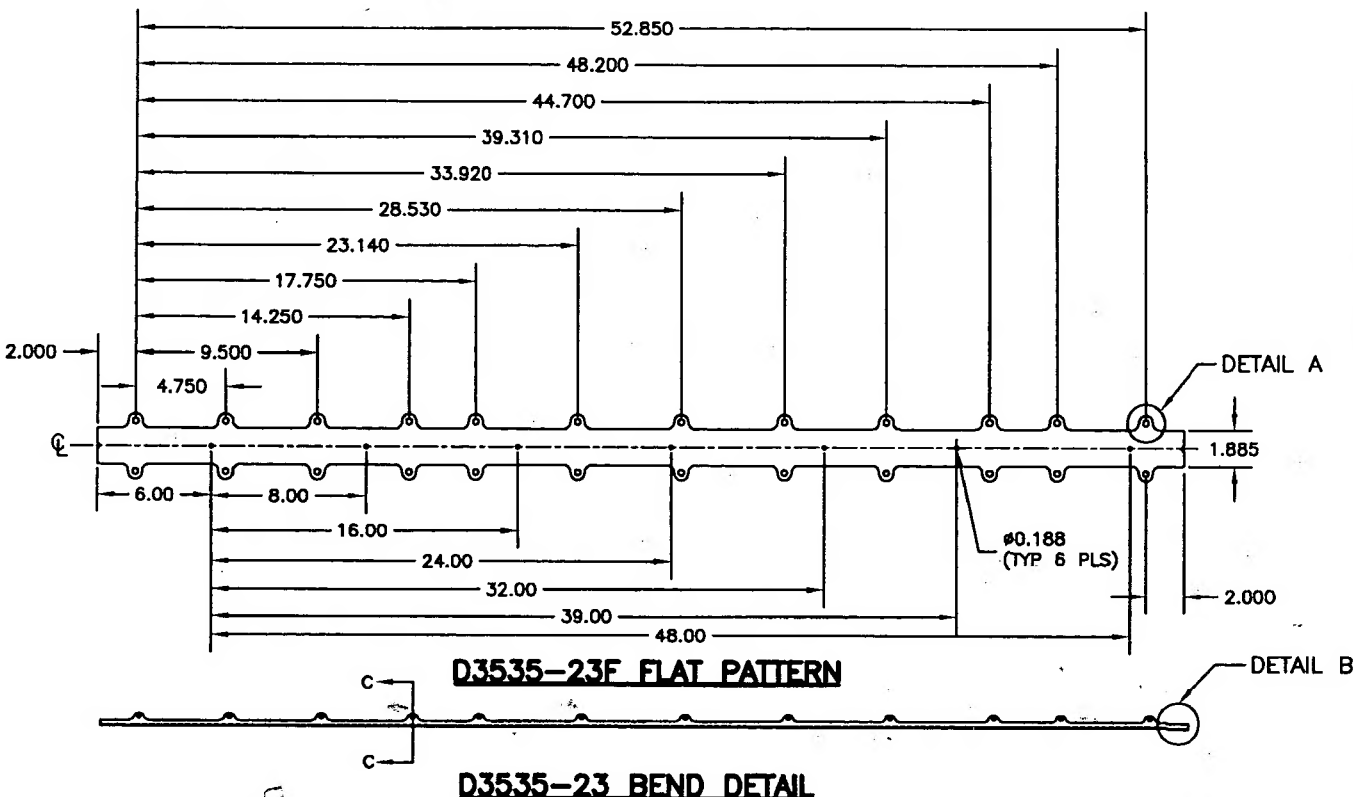
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| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 3 OF 7             |
|         |                    |             |                    | SCALE 1:10               |



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**NOTES**

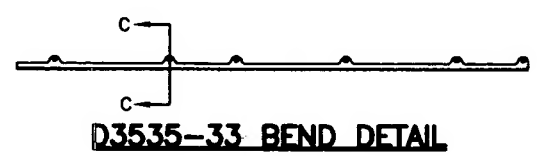
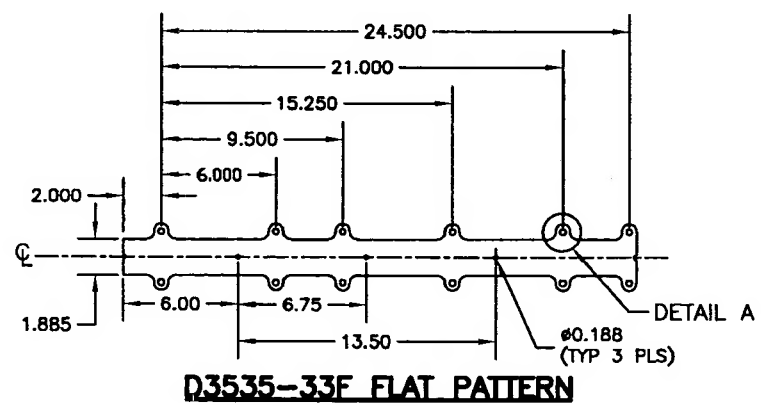
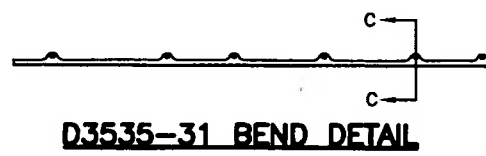
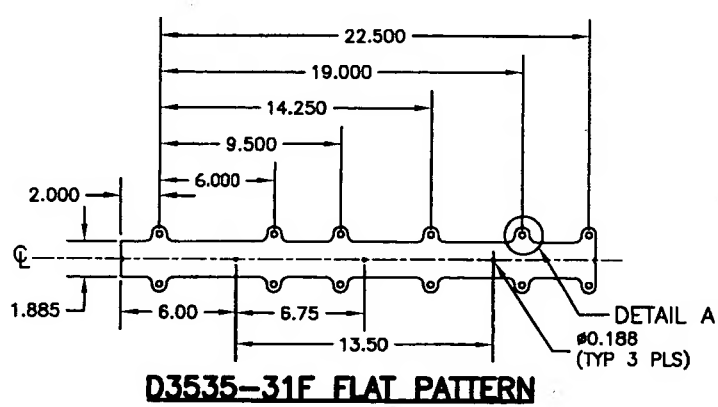
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION





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|         |                    |             |                    |                          |
|---------|--------------------|-------------|--------------------|--------------------------|
| DESIGN  | C B                | DRAWN BY    | CH                 | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED    | <i>[Signature]</i> | PORT HADLOCK, WA         |
| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 4 OF 7             |
|         |                    | SCALE       | 1:10               |                          |



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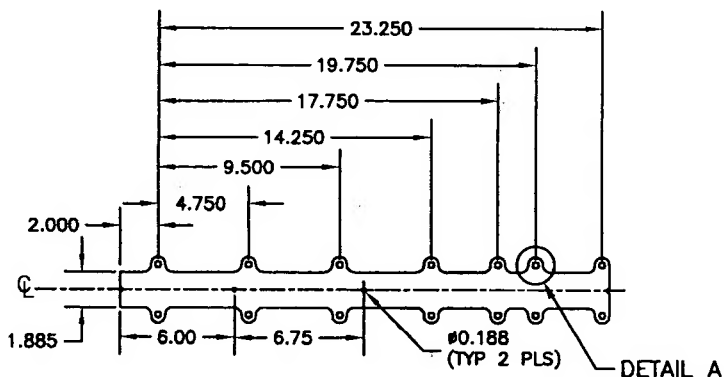
- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
  - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
  - 8) SEE PAGE 7 FOR DETAILS AND SECTION

# DART

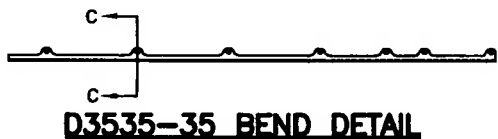
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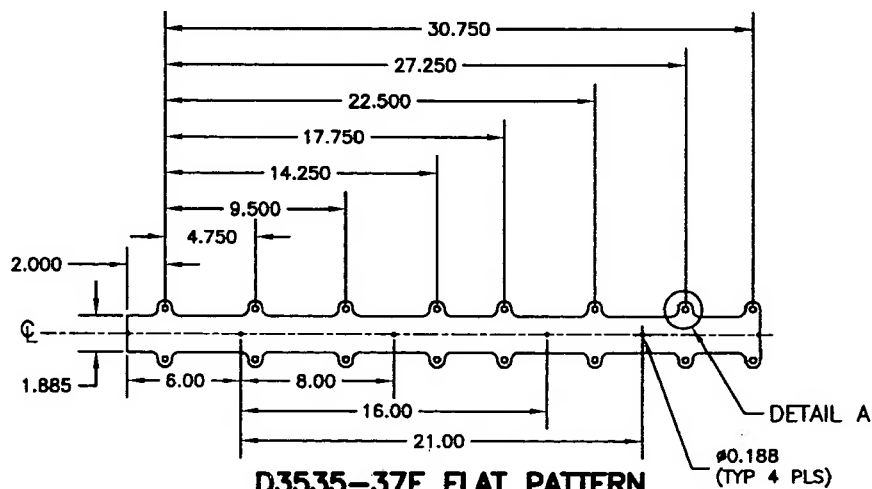
|         |                    |             |                    |                          |
|---------|--------------------|-------------|--------------------|--------------------------|
| DESIGN  | C.B.               | DRAWN BY    | M.H.               | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED    | <i>[Signature]</i> | PORT HADLOCK, WA         |
| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 5 OF 7             |
|         |                    | SCALE       | 1:10               |                          |



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

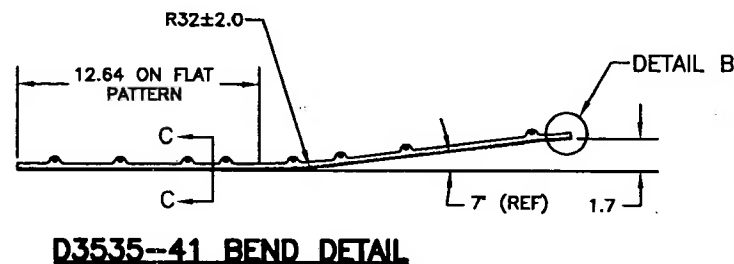
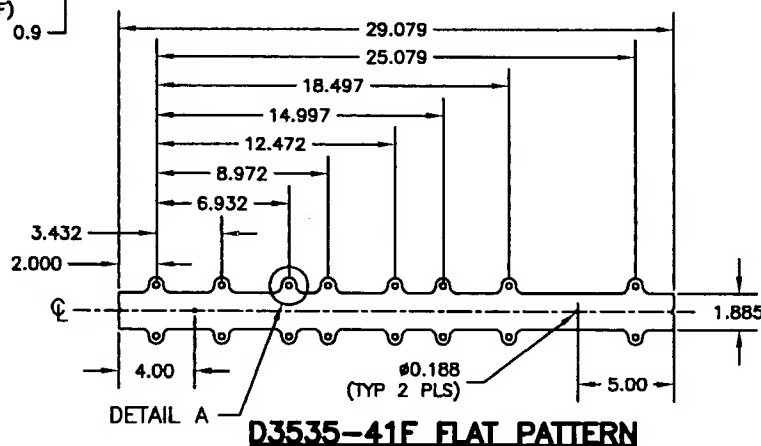
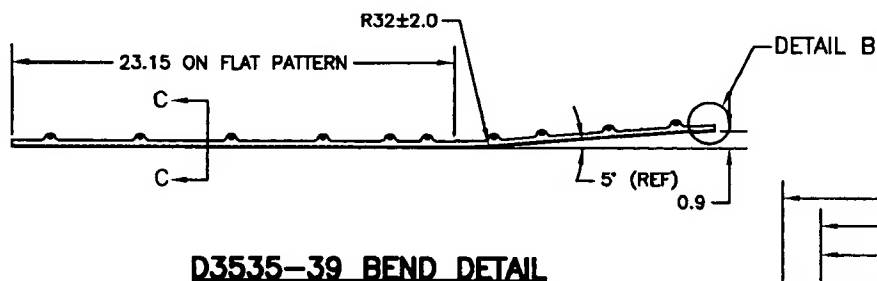
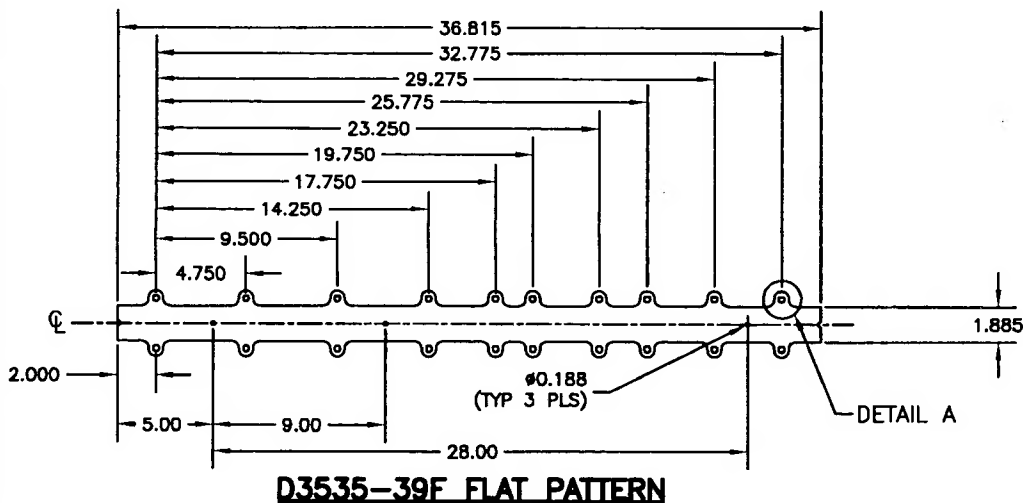
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| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 6 OF 7             |
|         |                    | SCALE       | 1:10               |                          |



**NOTES**

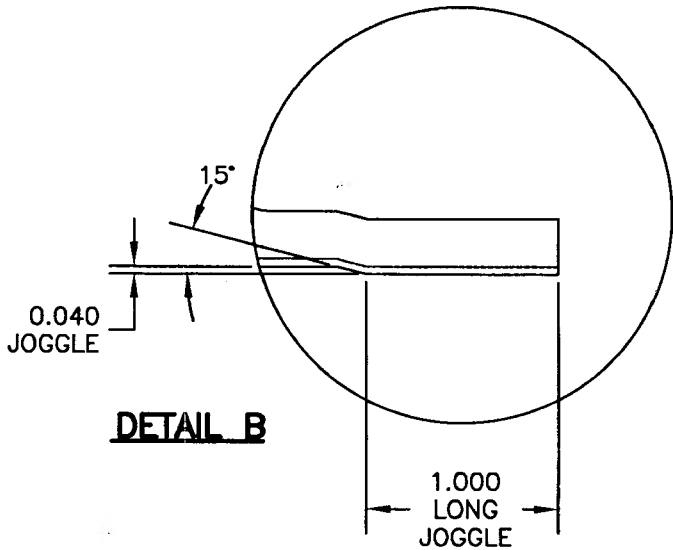
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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WORK ORDER  
NO 36424

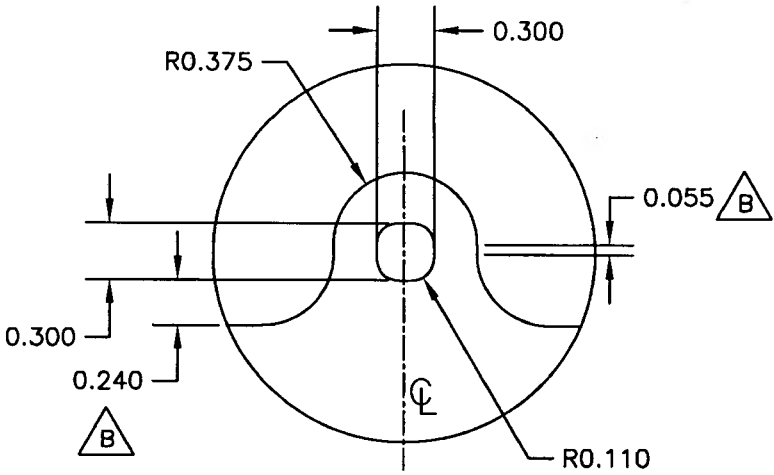


|         |                    |             |                    |                          |
|---------|--------------------|-------------|--------------------|--------------------------|
| DESIGN  | CB                 | DRAWN BY    | AM                 | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED    | <i>[Signature]</i> | PORT HADLOCK, WA         |
| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 7 OF 7             |
|         |                    | SCALE       | 1:1                |                          |

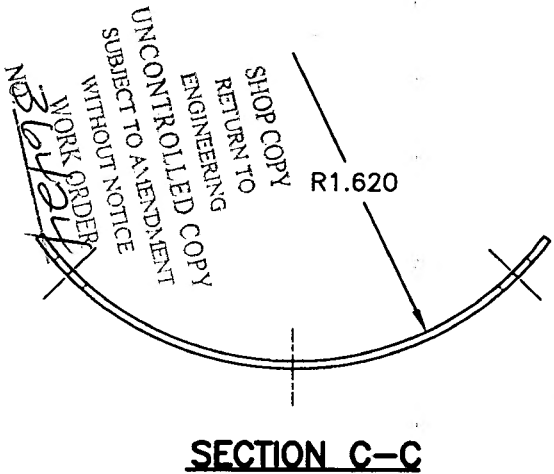
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07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C